· 465502

DART AEROSPACE LTD	Work Order:	21768
Description: Outer Fwd Saddle	Part Number:	D5951
Drawing: D5951 Rev. A	Qty:	6

03.05.16

Step	Location	Procedure	Ву	Date	Qty
1	EXPEDITING	Issue Work Order			,
		Dwg not required	MA	04.10,22	0
2	STORES	Issue material from stock: D6101-013 (7075-T7351)			
	1	Cut Size 2.50" x 10.10" X 8.25" (Grain along 10.10")			/
		Batch: <b>6</b> 2/800	J.L	.05/0g/cz	6
3	HAAS	Setup W/O No. 21768			
		Setup Inspection last completed	J.L	05/05/13	6
4	HAAS	Machine as per folio D5951		100	
		Ensure Batch Number is entered	I	05/05/03	6
5	HAAS	Deburr and Tumble			/
			IL	05/05/03	6
6	QC	Inspect Level 1			
		Fill Out Inspection Sheet	JL	05/05/03	6
7	QC	Inspect Level 8	1/.		,
		Audit Inspection Sheet	15	0305.03	۵
8	METAL	Acid etch and alodine as per QSI 005 4.1	1		,
			1111	US 05 12	6
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	3.4		,
			m	05 05 12	6
10	QC	Inspect Level 3	- 4		
			$C\mathcal{J}$	05/05//7	6
11	STORES	Pack in foam, identify and stock	, ,		-
			62	05/05/17	6
12	EXPEDITING	Close Work Order		7	4
		Cost/Part: 226,11 Sac 0xf05/18 (6)	dd/	05.05.24	6

Rev	Date,	Change	Revised By	Approved
Α	97.03!05			
В	99:04:19	Re-format	DM	
Ç	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED

02/02/06 M

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES							
DATE	STEP	-PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector			
	,					·				

٠.	W	WORK ORDER NON-CONFORMANCE (NO					
	Description of NC		Corrective Action Section B	Varification	Approval	Approval	
STEP	Section A	Initial Design Mgr	Action Description Sign & Date	Section C	Design Mgr	Approval QC Inspector	
ŀ							
		,					
			·				
	,						
	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Design Mgr	STEP Description of NC Section A Corrective Action Section B Initial Design Mgr Design M	STEP Description of NC Section A Corrective Action Section B Sign & Design Mgr Design Mgr Section C Section C	STEP Description of NC Section A Design Mgr Sign & Date Design Mgr Section B Sign & Date Design Mgr Section C Section C Design Mgr Sect	

Part No:	PAR #:	Fault Category:	NCI	R: Yes	No	DQA:	Date:	
NOTE: Date & initial all entries	·		<b></b>	QA:	N/C C	losed:	Date:	•

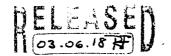
DART AEROSPACE LTD	Work Order:	21768
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5951 Rev. A and record below:

	<u> </u>			Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682				8		
В	1.745	1.755		1.750	1.750	1.750	1 749		
С	5.245	5.255		5.250	5248	5.248	5.248		
D	6.995	7.005		7.002	7.003	7.002	7.002		•
E	5.745	5.755		5.749	5.750	5.750	5.750		
F	4.745	4.755		4.728	447/8	4.749	4.742		
G	0.313	0.318	DT8686				7		
Н	1.522	1.532		1.527	1.526	1.526	1.526		
ı	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4-580	4.580	4.879	4.5/80		
K	0.313	0.318	DT8686		7	1	V		
L	0.240	0.260		. 250	.248	-251	-351		
М	0.490	0.510		5001.506	.505	.506	506		*
N	0.240	0.260		. 250	. 248	.253	-256		
0	7.990	8.010		8.006	8-006	8.005	8006		
Р	0.240	0.260		-260	. 251	260	.260		
Q	0.307	0.312		.312	. 311	-312	.312		
R	0.760	0.765		761	-761	-761	-761		
S	0.490	0.510		,504	. 502	. 502	- 503		
Ť	1.375	1.395		1.375	1.382	1378	1-378		
U	2.000	2.020		7.000	2.000	2.000	2.000		
V			ATT ATT ATT			3.000			·_···
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AG						-			
AH						<del></del>			
	Acc	ept/Reje	ct	-					

	1	
Measured by: 17/	/ <i< th=""><th>Audited by</th></i<>	Audited by
Mododiod by. (3)	/ <u> </u>	
Date: 05/65/02	05/05/03	Date: OS からでを

Г	Rev	Date	Change	Revised by	Approved
	Α	99.04.19	New Issue	RF	W
	В	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	



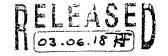
DART AEROSPACE LTD	Work Order:	21768
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5951 Rev. A and record below:

				Red	corded Actu	al Dimension	ons		
Dim	Min	Max	Go/No Go Gauge	1 /	2/	3	4	Ву	Date
Α	0.438	0.443	DT8682						
В	1.745	1.755		1.750	1.749				
С	5.245	5.255	· · · · · · · · · · · · · · · · · · ·	5-248	5.247				
D	6.995	7.005		6.999	7.000				
E	5.745	5.755		<i>5.</i> 780	5.750				
F	4.745	4.755		4.749	4-7,50		•		
G	0.313	0.318	DT8686						
Н	1.522	1.532		1.526	1527				
1	3.048	3.058		3.053	3.053				
J	4.575	4.585		4-5778	4.579				
K	0.313	0.318	DT8686		<i>J</i> .				
L	0.240	0.260		-252	- 246				
М	0.490	0.510		. 504	. SOS				
N	0.240	0.260		-254	. 248				
0	7.990	8.010		8.005	8.005				
Р	0.240	0.260		-259	-260				
Q	0.307	0.312		.3/2	-312				
R	0.760	0.765		-761	.761				
S	0.490	0.510		.502	-501				
T	1.375	1.395		1.375	1.390				
U	2.000	2.020		2.000	2.000				
V			*						
W			<del></del>						
Х									
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Z	M-1_0_0_0								
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Measured by: 」」、	Audited by 16
Date: 05/05/03	Date: OSODO DE

Rev	Date	Change	Revised by	Approved
Α	99.04.19	New Issue	RF	W
В	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	



## Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Oct 21, 2004 08:51 am

Work Order No : 0021768

Project Name : D5951

Project For : WK446 Work Order Type : Main

Main WO Number :

House Part Number: D5951

Description : Saddle Manufactured : Yes

Amount Req'd:

Amount Done : 0
Start Date : 10-20-04

Est Finish Date : 11-11-04

Act Finish Date : Drawings Reqd : No

Ok for Approval :

Approval Rec'd

Department Code:

Burden Flags : NNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date : /

Invoice Number :

Invoice Amount : 0.00

Order Entry No : 4

OE Value : 0.00

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

	1.4	Estimated	Actual	Var. %	Posted	To Post
=======================================	===	=========	=========	=======	=========	=========
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00.	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		•
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	4	
CNC	:	0.00	0.00	0.00	<sup>13</sup> 0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	========	======		
Burden	:	0.00	0.00	0.00		
		========	========	======	1°	
Total Cost	:	0.00	0.00	0.00		•
Margin	:	0.000	0.000			
Selling.Cost	:	0.00	0.00			

		Estimated		Actual
Labour Hrs/Amount Done	:	0.00	•	0.00
Profits/(Loss)	:	0.00		0.00